












Date: Thursday, 24/04/2008 3:28:13 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : R44 CARGO MIRROR
<b>Job Number</b> : 38776	
<b>Estimate Number</b> : 10095	
<b>P.O. Number</b> :	<b>Part Number</b> : D044715011
<b>This Issue</b> : 24/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3243
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 37316	<b>Material</b> : Manufacture in multiples of 10
<b>Written By</b> :	<b>Due Date</b> : 15/05/2008 <b>Qty</b> : <del>10</del> Um: Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.4.24</u>	
<b>Comment</b> : Est Rev:A 04.02.18 New issue KJ/JLM Est Rev:B 06-04-28 Manufactured on Water Jet JLM	Had to do 9 due to lack of D1049 + time OK from Line.
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0 DC	DOCUMENT CONTROL
	
JLD 08.5.29 @ CHG002 Sooty	
<b>Comment:</b> DOCUMENT CONTROL	
Photocopy bluefile & type labels per PPPD044-715-011	CHG001 002 per 4/19/08
2.0 M6061T6S063	6061-T6 .063 Sheet
	
7.	
<b>Comment:</b> Qty.: 0.5359 sf(s)/Unit Total : 5.3592 sf(s)	
Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3243.1	
Batch: <u>107327</u> <u>B 8-4-28</u>	
3.0 WATER JET	FLOW WATER JET
	
<b>Comment:</b> FLOW WATER JET	
1-Cut as per Dwg D3243	
Dwg Rev: <u>A</u> <u>B 8-4-28</u>	
Prog Rev: <u>A</u>	(12)
2-Deburr if necessary <u>B 8-4-28</u>	
4.0 QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	
<u>B 8-4-28</u>	
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE	
5.0 QC8	SECOND CHECK
	
<b>Comment:</b> SECOND CHECK	<u>S 08/04/28</u> (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/04/2008 3:28:13 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 38776

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SB

08/05/02

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/05/02 (12)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

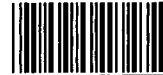
M-1

08/05/02

(12X)

9.0

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-02

(12)

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 FE-032EF

Insert

M105385 (9)

M107896 (39)

1 D3243-1(Ref)

Bracket

B 38776 (12)

SB 08/05/20

(12)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

CB 08/05/20

(12)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/20 (12)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M105642

(12X)

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1

08/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/04/2008 3:28:13 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 38776

Part Number: D044715011

Job Number:



Seq. #: Machine Or Operation: Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20 am  
320°F  
7:50 am

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 08/05/21

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1048

Clamp

B35037

AS 08/05/21

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1049

Saddle

B36465 x 1 B32797 x 4

Need to add 1 more  
Back to stock  
comp want let me  
do it after 4 tries. + 36465.

AS 08/05/21

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2010-104

Arm

~~B37722~~ x 1 B38796 x 9

Add 1 to stock  
38796

AS 08/05/21

19.0

D2011101

6" Mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2011-101

Mirror

B38288

AS 08/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 24/04/2008 3:28:13 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 38776

Part Number: D044715011

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 ALS41032130 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130Insert

M105819

AS 08/05/21

(X9)

(X9)

21.0 AN34A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A Bolt

M103041

AS 08/05/21

(X9)

(X9)

22.0 AN526C1032R10 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw

M1224 M15072

AS 08/05/22

(X9)

23.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer

M104885

AS 08/05/21

(X9)

24.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/05/29

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location:

940 X.P.P. Rev A

ST229 3 left were stacked

AS 08/05/29

(X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 24/04/2008 3:28:13 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 38776

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

2005/30

Job Completion



u 08/05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

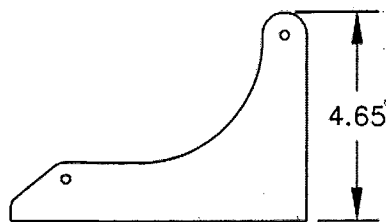
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

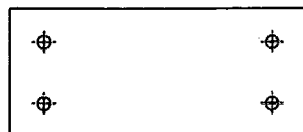


**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

 $2.75^{+0.030}_{0.000}$ 

**RELEASED**  
04.02.03 *HA*

8.581  
8.206  
7.706

GRAIN  
DIRECTION

11.920  
11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

**D3243-041 BRACKET ASSEMBLY  
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

4.214  
R0.25 (TYP)  
3.339  
R0.38 (TYP)

5.494

R2.75  
(TYP)

D3243-1  
FLAT PATTERN

R0.50  
(TYP)

3. SHQP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38176

6.560

5.810

5.360

0.500  
0.000  
0.750  
0.500  
0.000

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Date: Thursday, 24/04/2008 3:28:13 PM  
 User: Julie Lecocq

## Process Sheet

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<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : R44 CARGO MIRROR
<b>Job Number</b> : 38776	
<b>Estimate Number</b> : 10095	
<b>P.O. Number</b> :	<b>Part Number</b> : D044715011
<b>This Issue</b> : 24/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3243
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 37316	<b>Material</b> : Manufacture in multiples of 10
<b>Written By</b> :	<b>Due Date</b> : 15/05/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 08.4.24	
<b>Comment</b> : Est Rev:A 04.02.18 New issue KJ/JLM	
Est Rev:B 06-04-28 Manufactured on Water Jet JLM	

## REFERENCE ONLY

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD044-715-011 CHG001

2.0

M6061T6S063

6061-T6 .063 Sheet



Comment: Qty.: 0.5359 sf(s)/Unit Total : 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: \_\_\_\_\_

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK